

Work Order ID 84637

84637

Page 1

May-17-12 11:52:13 AM

Item ID: D3531-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket Assembly

Start Date: 17/05/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/22

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3531	Rev A

100 0.00

100

Small Fab

Small Fab

Memo

Small Fab

Assemble as per dwg D3531

110 0.00

110

QC5- Inspect part completeness to step on W/O

QC

Memo

Quality Control

120 0.00

120

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Powdercoat

Memo

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

11:30
3200F

12:00

ML 21274

5X 12/06/05

20 12/06/05

5X 12/06/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

May-17-12 11:52:17 AM

Page 1

Work Order ID: 84637

84637

Parent Item: D3531-041

D3531-041

Parent Item Name: Bracket Assembly

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3531-1 *D3531-1* Bracket		Manufactured	No			100	Each	2.0000	1	5			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		2							
					83013	2							
D3531-3 *D3531-3* Bracket Front Plate		Manufactured	No			100	Each	1.0000	1	5			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		1							
					61781	0							
					83014	1							
MS20470AD4-4 *MS20470AD4-4* Rivet, Universal Head		Purchased	No			100	Each	6,507.000	12	60			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST319		6507							
					116188	136							
					116391	66							
					118614	1046							
					119109	26							
					120361	228							
					121011	5							
					121556	2000							
					121652	3000							

Handwritten notes and signatures:

384635
3x
384636 (JW)
43
17

Signatures:
E. B. 12/06/05
E. B. 12/06/05
E. B. 12/06/05

W/O:		WORK ORDER CHANGES					
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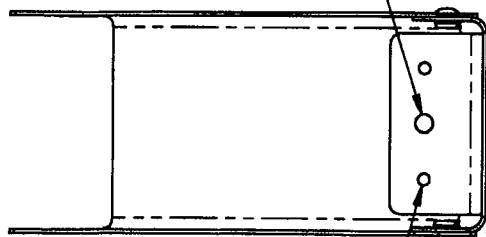
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NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED HA	DRAWING NO. D3531	REV. A SHEET 1 OF 3
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SCALE 1:2
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE	

△
4
TRANSFER DRILL #9 (Ø0.196)



TRANSFER DRILL #30 (Ø0.129)
INSTALL MS20470AD4-4 RIVET
(2 PLACES)

△
4

RELEASED
07-08-03

D3531-3
BRACKET FRONT PLATE

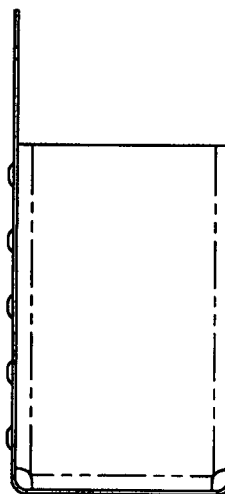
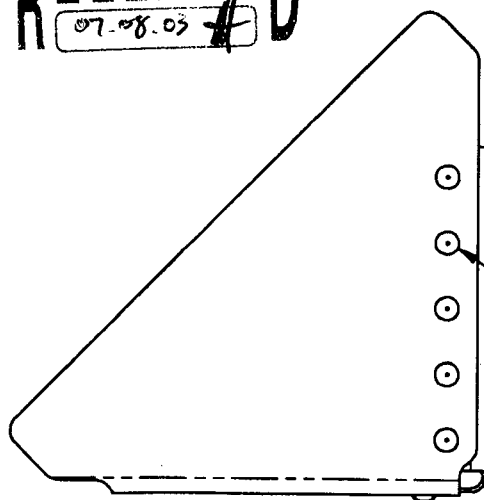
D3531-1
BRACKET

△
3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **04637 MLW**

12/05/22

MS20470AD4-4
(10 PLACES)



D3531-041 BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING
WHITE MARKER ON INSIDE OF BRACKET
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET
THROUGH D3531-3 BRACKET FRONT PLATE
BEFORE FINISHING

PARTS LIST

QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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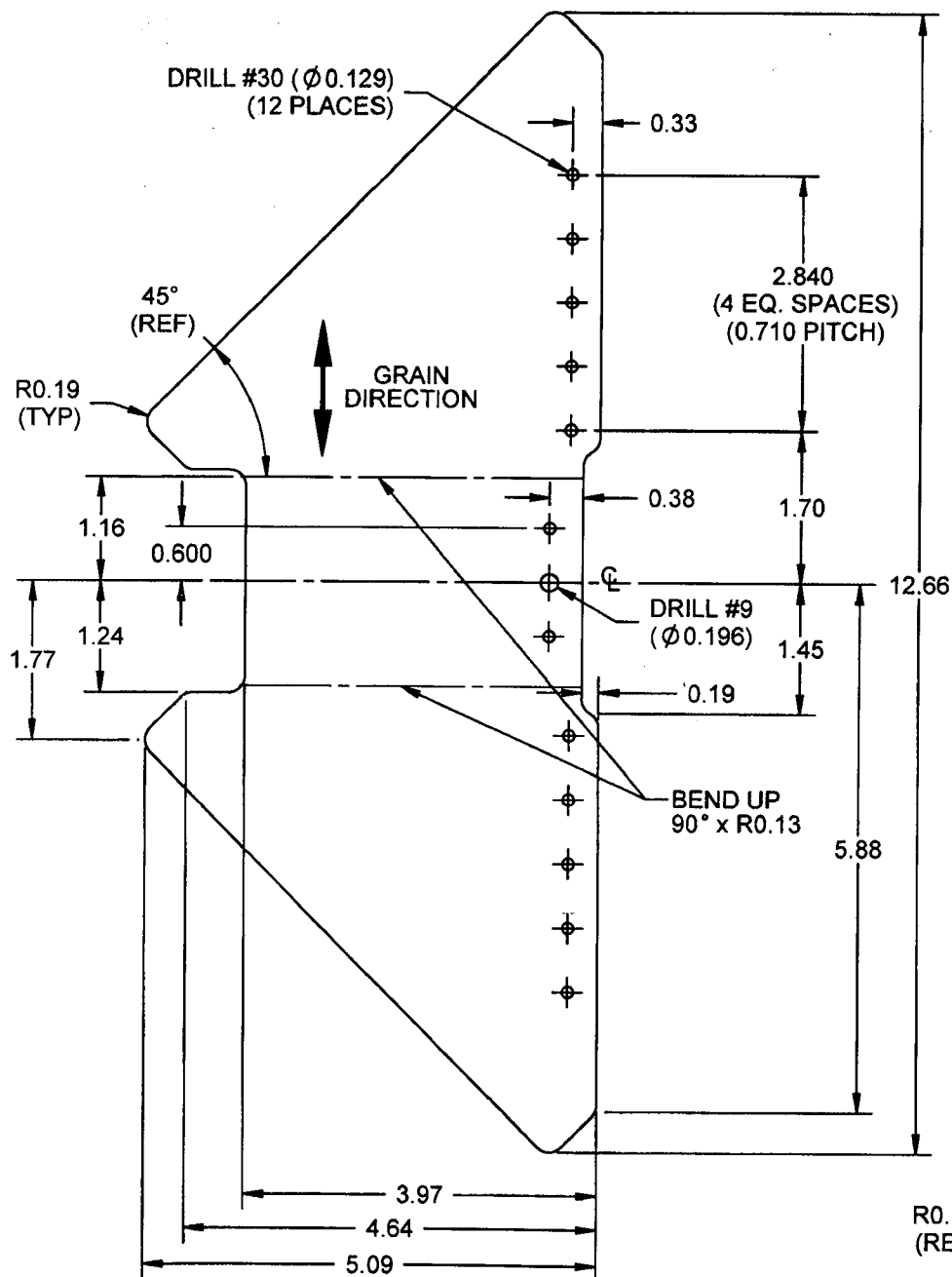
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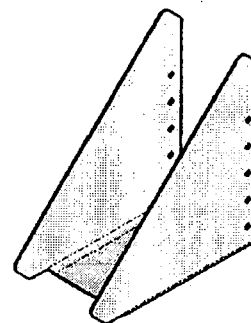
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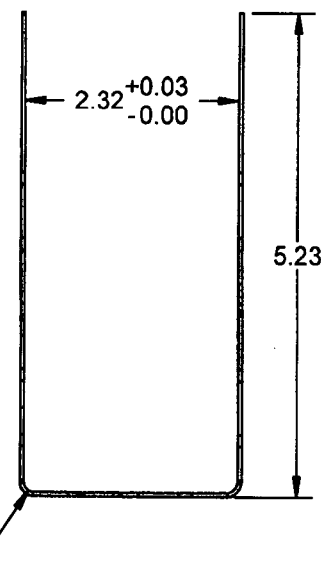
DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3531
DATE 07.06.19	TITLE BRACKET ASSEMBLY	REV. A SHEET 2 OF 3 SCALE 1:2



D3531-1F FLAT PATTERN



RELEASED
07.08.03



D3531-1 BRACKET

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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ts 9/10

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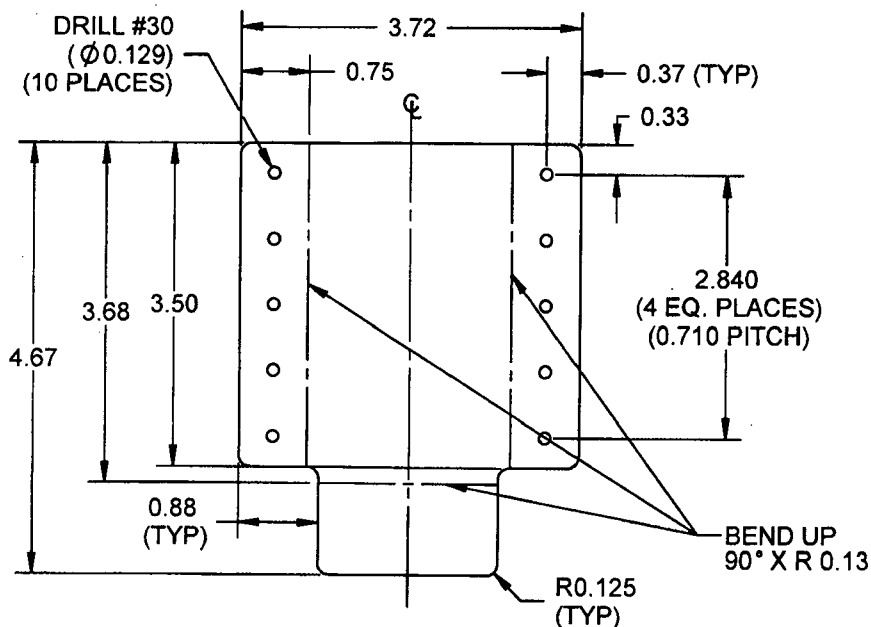
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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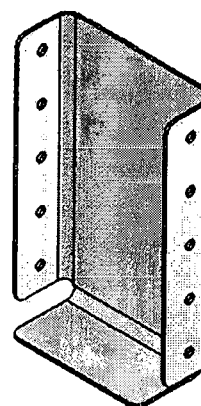
NOTE: Date & initial all entries



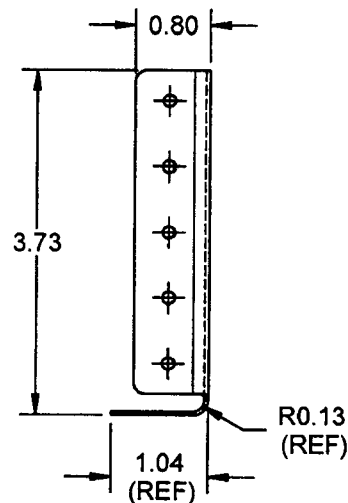
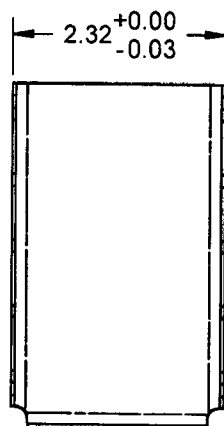
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CHECKED CE	APPROVED [Signature]	DRAWING NO. D3531	REV. A SHEET 3 OF 3
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SCALE 1:2



RELEASED
07.08.03 [Signature]



D3531-3F FLAT PATTERN



D3531-3 BRACKET FRONT PLATE

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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